

Date: Tuesday, 4/18/2006 9:58:56 AM
 User: Kim Johnston

Process Sheet

split 06/05/19 ③

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FOLDING STEP WELDMENT LH
Job Number : 26652	
Estimate Number : 10463	
P.O. Number : N/A	Part Number : D3388041
This Issue : 4/18/2006 S.O. No. : N/A	Drawing Number : D3388 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : LARGE FAB ASSY	Drawing Revision : A
Previous Run : 26156	Material : N/A
Written By : <i>See comment below</i>	Due Date : 5/10/2006 Qty: Um: Each
Checked & Approved By : <i>06.04.18 h</i>	
Comment : Est. B 05.06.10 Added Step 11 KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2622120C	Extrusion
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
 D2622-120C extrusion 8
 Batch: *324563*

PE 06.04.24 5

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1
 1-Cut D2622-120C extrusion 85.15" long as per Dwg D3388
 2-Deburr and bevel ends for welding

PE 06.04.24 5

3.0	D2734	206 Step Endplate
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)
 206 Step Endplate
 Pick:

Qty	Part Number	Description	Batch
2	D2734	End Cap	<i>324402</i>

PE 06.04.25 5

4.0	D33871	Arm
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)
 Arm
 Pick:

Qty	Part Number	Description	Batch
2	D3387-1	Arm	<i>325933-4 326161-6</i>

PE 06.04.25 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld arms and end caps as per Dwg D3388.

Inspect for foreign objects as per QSI 024. Dwg Rev: A

Grind end cap welds flush

welding rod 3 m19123

St 06.04.25 5
P4 06.04.27 5

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAO 06.05.04 2
M.F. 06.05.02 3

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

g.m 06/05/11

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3388 and QSI 005 4.4

FL 06 05 12

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Inspect Powder Coat and Wing Walk

SB 06 105 / 19

10.0

D2808

Spacer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Spacer

Pick:

Qty	Part Number	Description	Batch
1	D2808	Spacer	<i>B26648</i>

B26648

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Press spacer into D3387-1 arm as per Dwg D3387

SAH 06.06.06 (3)

W/O:





WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06.05.05	6a	weld last end cap as per dwg. S3388 inspect for foreign objects					
	6b	inspect for foreign objects as per Q51 Q24.	14	06.05.05	5		
	6c	weld last end cap as per dwg. S3388 grid end caps welds flush FF 06.05.05	14	06.05.05	5		
	6d	weld inspection QC 5/9					
	d						

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/06/15
 QA: N/C Closed: _____ Date: _____

NCR:

WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06.06.06	11	2 x D2808 were crushed during press fit.		Remove & replace. Verify hole size for damage on step Arm. 507 ± 0.0 -0.001 .	SAP 06.06.06			

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Seq. #:

Machine Or Operation:

Description :

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB

06/06/11

(3)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SAD

06-06-12

(3)

14.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/06/13

(3)

Job Completion



06-06-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

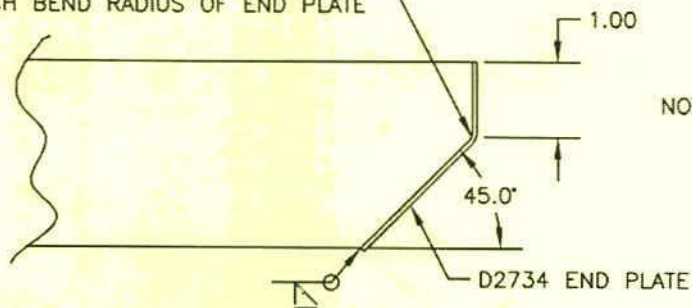
DART

RELEASED

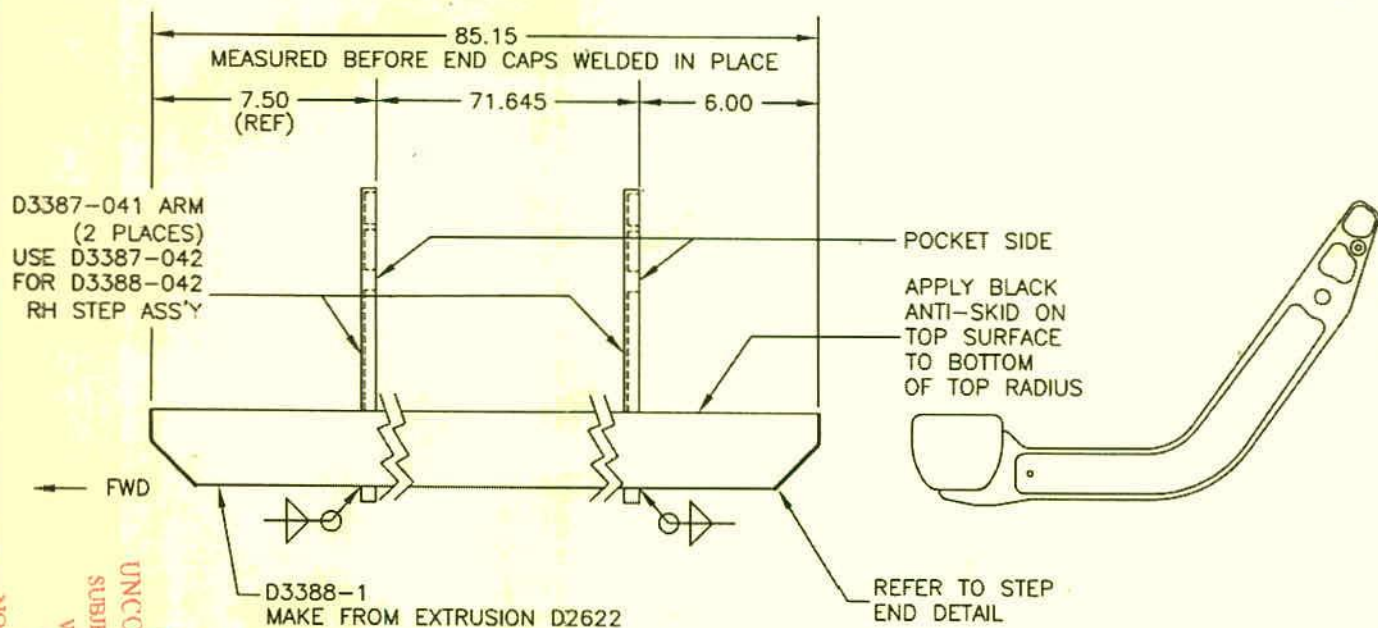
05-03-11

NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004

ROUND CORNER OF EXTRUSION TO MATCH BEND RADIUS OF END PLATE



TYPICAL STEP END DETAIL
NOT TO SCALE



D3387-041 ARM
(2 PLACES)
USE D3387-042
FOR D3388-042
RH STEP ASS'Y

POCKET SIDE

APPLY BLACK
ANTI-SKID ON
TOP SURFACE
TO BOTTOM
OF TOP RADIUS

REFER TO STEP
END DETAIL

D3388-1
MAKE FROM EXTRUSION D2622

D3388-041 LH STEP ASSEMBLY (SHOWN)
D3388-042 RH STEP ASSEMBLY (OPPOSITE)

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) WELD PER DART QSI 004 UNLESS OTHERWISE NOTED
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ENTIRE ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

DESIGN	DRAWN BY	DART AEROSPACE LTD
CP	CP	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
CP	CP	D3388
DATE	TITLE	REV. A
05.01.20	STEP WELDMENT	SHEET 1 OF 1
A	05.01.20	NEW ISSUE
		SCALE
		NTS

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26652

